

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016172**Date Inspected:** 20-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13 section**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Caltrans QA inspector along with Caltrans Engineer Mr. Roman Granados and OBG SMR Mr. James Devey attended the meeting at 0830 Bay #13 ZPMC office with ZPMC, TYL and ABF engineers. Caltrans QA inspector in the meeting performed translation for Caltrans engineers. The meeting is discussing the OBG section #13 and #14 the error for drawing, welding detail, design changes and technical issues.

Bay#16

Caltrans QA inspector observed two ZPMC welding operator performed semi-automatic SAW CJP process on plate to plate of longitudinal diaphragm. The CJP weld is designed butt joint with back gouging welded flat position (1G). The longitudinal diaphragm, plate ID and weld number are LD3034/X3759A, X3759B /LD3034-001-005 side A and LD3031/X3774A, X3754B/LD3031-001-003 side A of 13AW west line section. The region of the weld joint has been pre-heating to specific desired temperature prior SAW welding. The parameters used for the SAW CJP welding of the longitudinal diaphragm were conducted in accordance with Caltrans approved WPS. The SAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA inspector observed two ZPMC heat straightening operators performed heat straightening on the longitudinal diaphragm with ZPMC heat straightening report #HSR1(B)8791. The longitudinal diaphragm ID are

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LD3033 and LD3034. The heating temperature is maximum 650 C (1200 F) and cool in still air. All the plates for heat straightening have been inspected and recorded by ZPMC QC. Based on Caltrans QAI observation, no discrepancies were noted.

Bay # 14

Caltrans QA inspector observed a ZPMC cutting group performed a semi-automatic thermal oxyacetylene cutting on the 100mm thick plate. The thermal oxyacetylene cutting used is operator practice prior OBG section 13 bottom plate production cutting. Total four holes have been cut and each hole has failed with adhering oxide films and notch located inside of hole surface. ZPMC Bay #14 foreman informed Caltrans QA inspector that hole cutting will discuss with the engineer for better method.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
